

Date: Wednesday, 07/01/2009 1:36:43 PM  
 User: Julie Dawson

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 44473 -2  
 Estimate Number : 12883  
 P.O. Number :  
 This Issue : 07/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : MACHINED PARTS  
 Previous Run : 41068  
 Written By : *[Signature]* 07-01-09  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07.05.24 EC  
 Est Rev B ECN 987 07.10.09 EC  
 Est Rev:C ECN1048 07-12-18 DD verified by: EC

Drawing Name : ARM  
 Part Number : D3560043  
 Drawing Number : D3560 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 Material :  
 Due Date : 23/01/2009

Qty: 4 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .500 x 5.00



Comment: Qty.: 1.3598 f(s)/Unit Total : 10.8780 f(s)  
 6061-T6 Bar 0.50" x 5.00"  
 Batch: 110550

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks 15.500" long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: *B* & Dwg D3560 Rev: *D*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 44473

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLATE 3446666

09-03-18 4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

### STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *th*
- 2- set up bracket and arm on jig *th*
- 3- preheat bracket and arm with torch *th*
- 4- clean before welding with brush *th*
- 5- set up machine to 135 amps *th*
- 6- weld across bottom and top ends *th*
- 7- reheat with torch ( 65 deg C ) *th*
- 8- on one side weld from bottom to top half way *th*
- 9- same for other side (half way) *th*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *th*
- 11- same for remaining side (ease off pedal near end) *th*

09-03-18 4

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/19 24

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-03-19 24

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09/03/19 24



Date: Wednesday, 07/01/2009 1:36:44 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 44473

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D2806

Bushing



Comment: Qty: 1.0000 Each(s)/Unit Total 8.0000 Each(s)

Spacer

batch: 642181 x4

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WIA

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



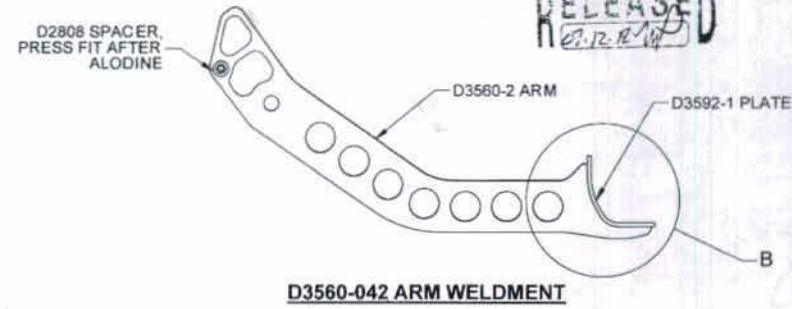
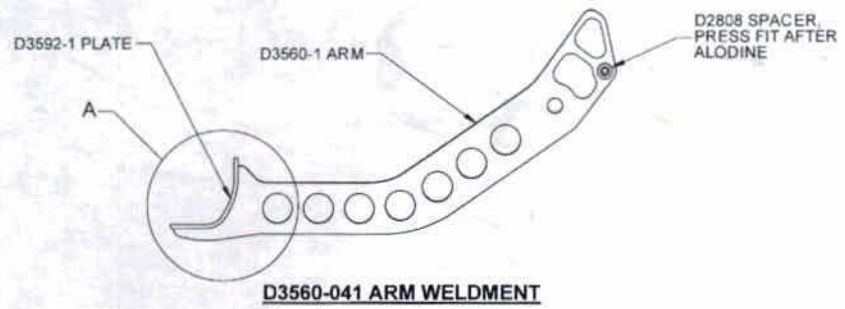
09/03/19 x4

MF 09-03-12

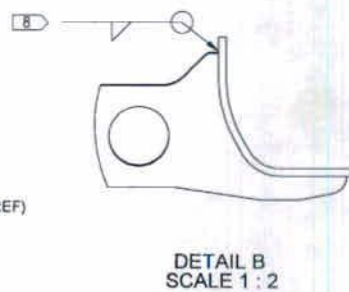
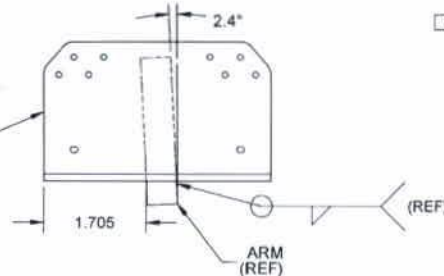
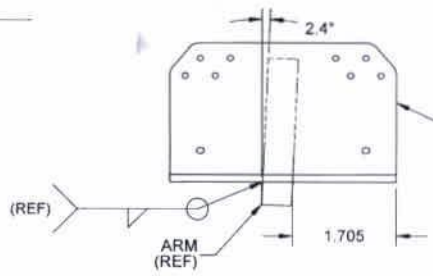
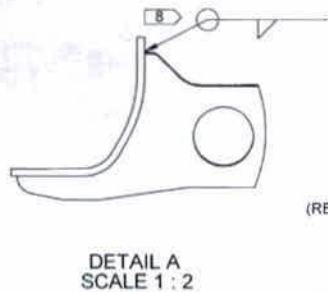
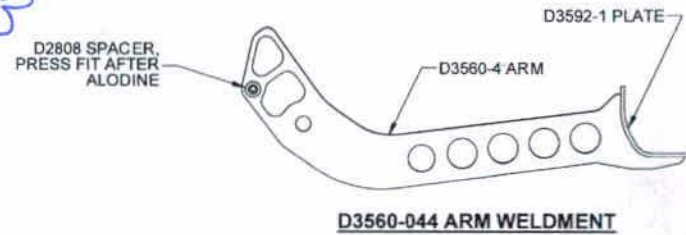
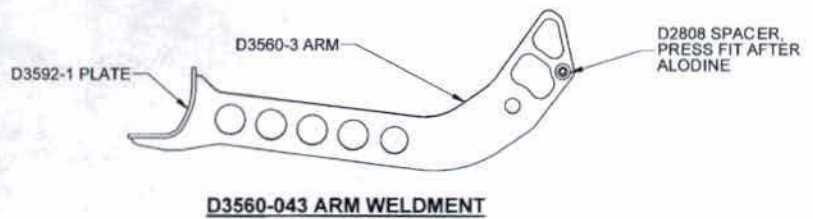




RELEASED  
02.12.14



*ufo 44473*



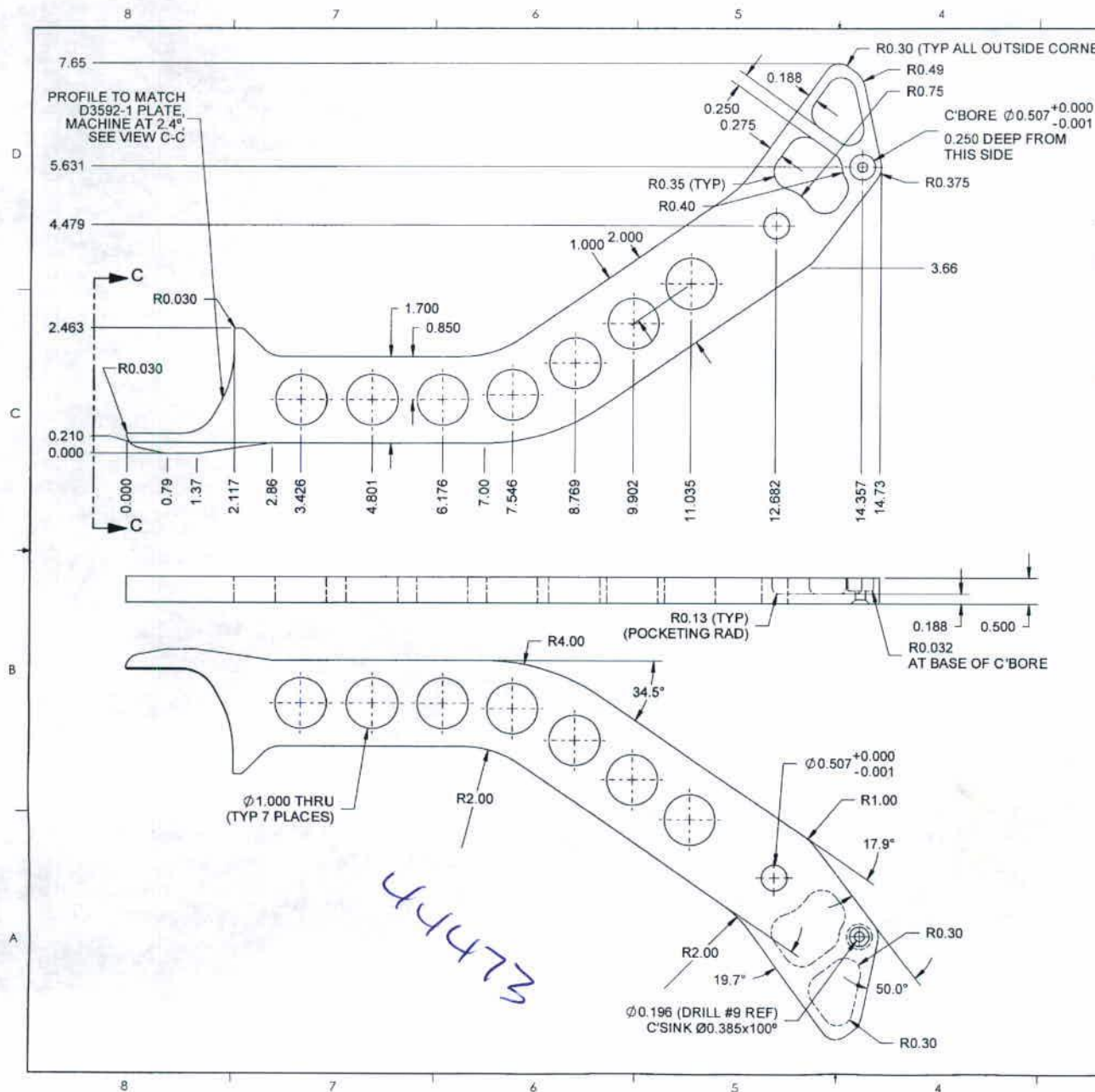
**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	<i>lpc</i>		
CHECKED	<i>5</i>		
MFG. APPR.	<i>REP</i>		
APPROVED	<i>REP</i>		
DE APPR.	<i>REP</i>		
DATE	07.11.16		

NOTES:  
1) MATERIAL: N/A  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.23 lbs (TYP)  
8) WELDING: PER DART QSI 004

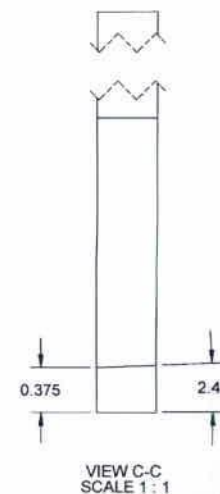
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. D3560  
TITLE ARM WELDMENT  
REV. D  
SHEET 1 OF 5  
SCALE 1:4  
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### D3560-1 ARM WELDMENT

#### NOTES:

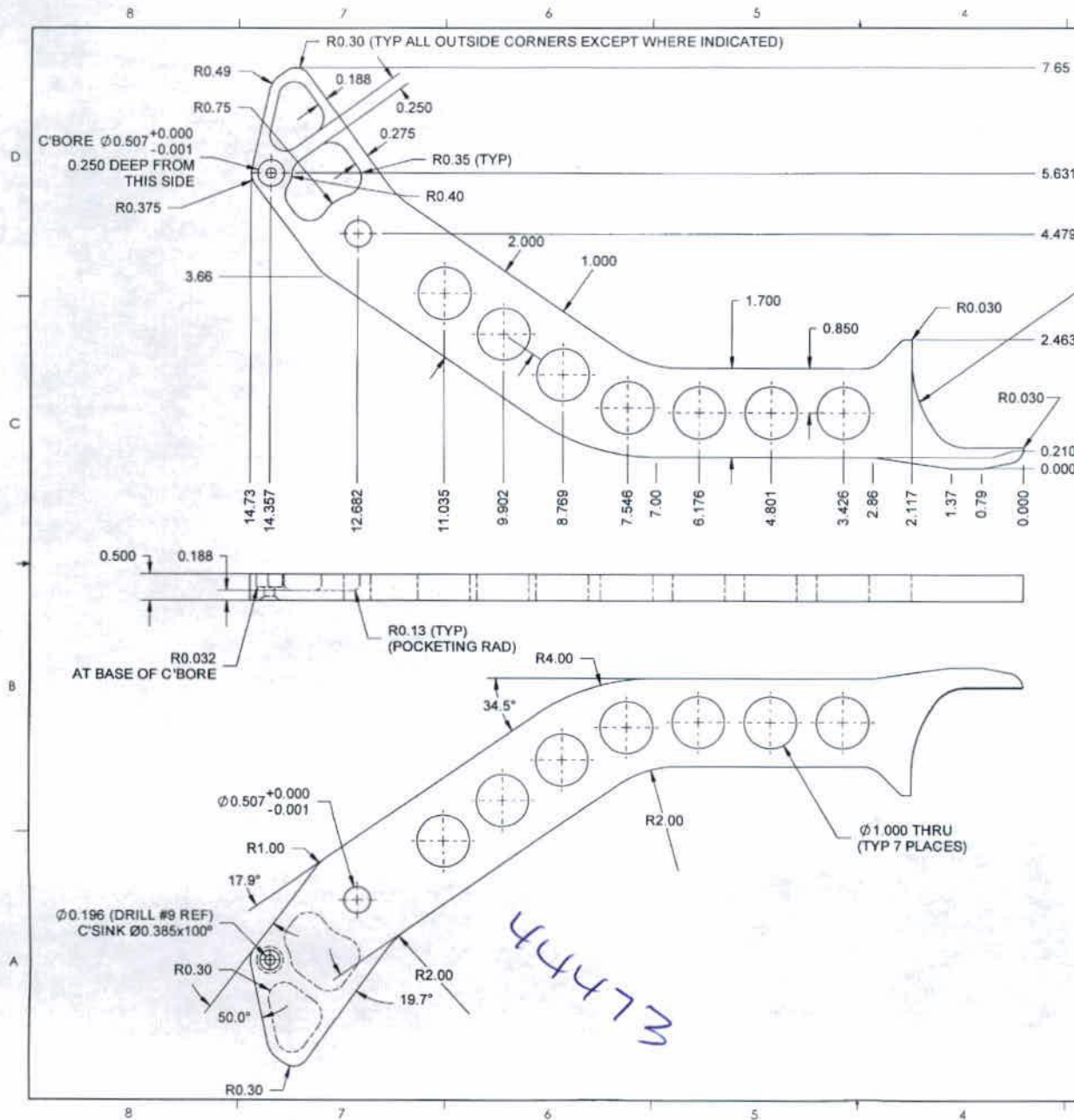
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



RELEASED  
07.12.11

DESIGN	QC	DART AEROSPACE LTD	
DRAWN	QC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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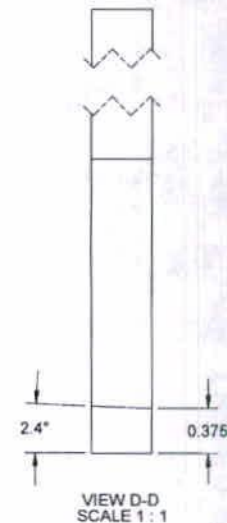




PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4°,  
SEE VIEW D-D

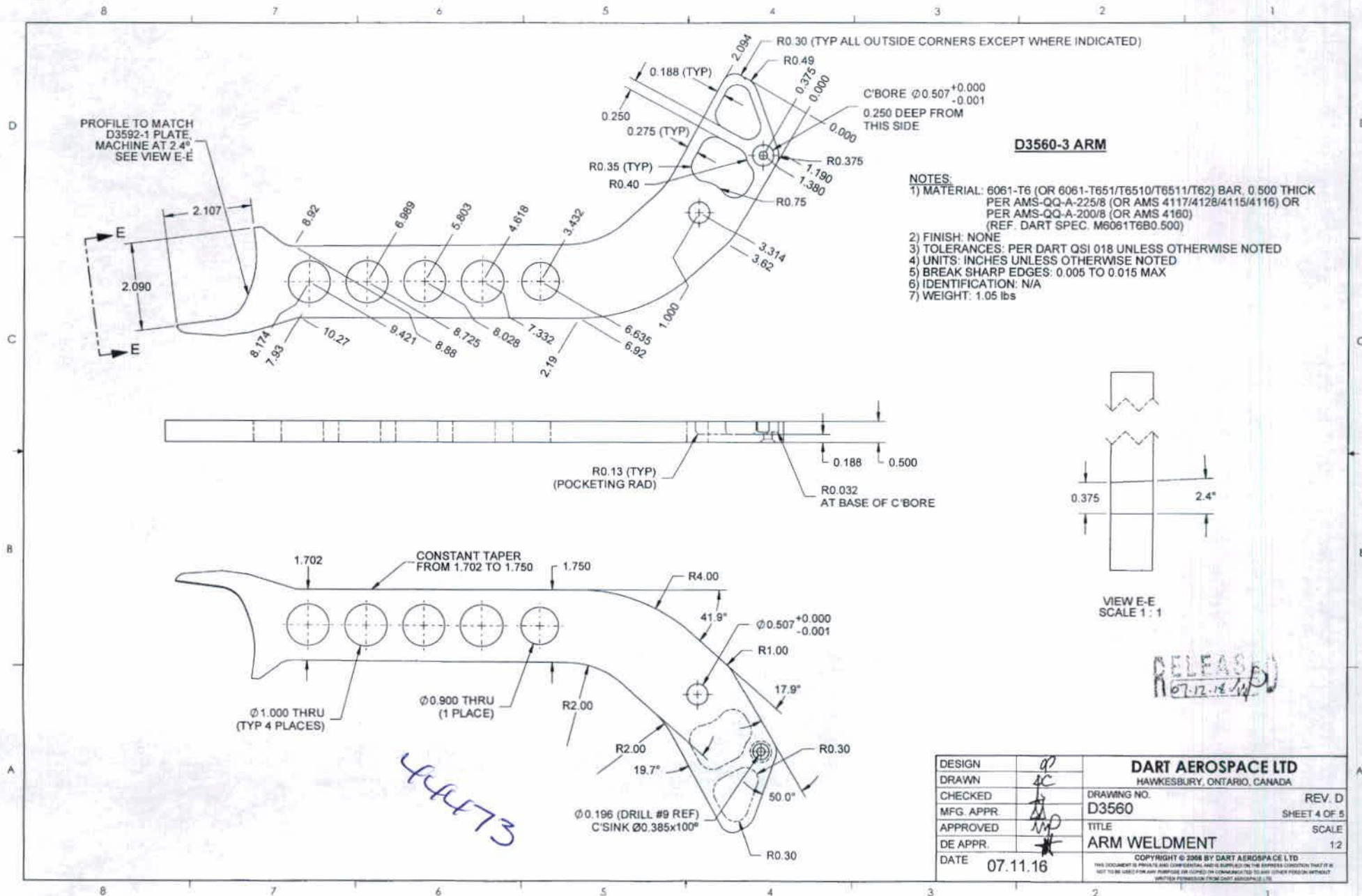
### D3560-2 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs

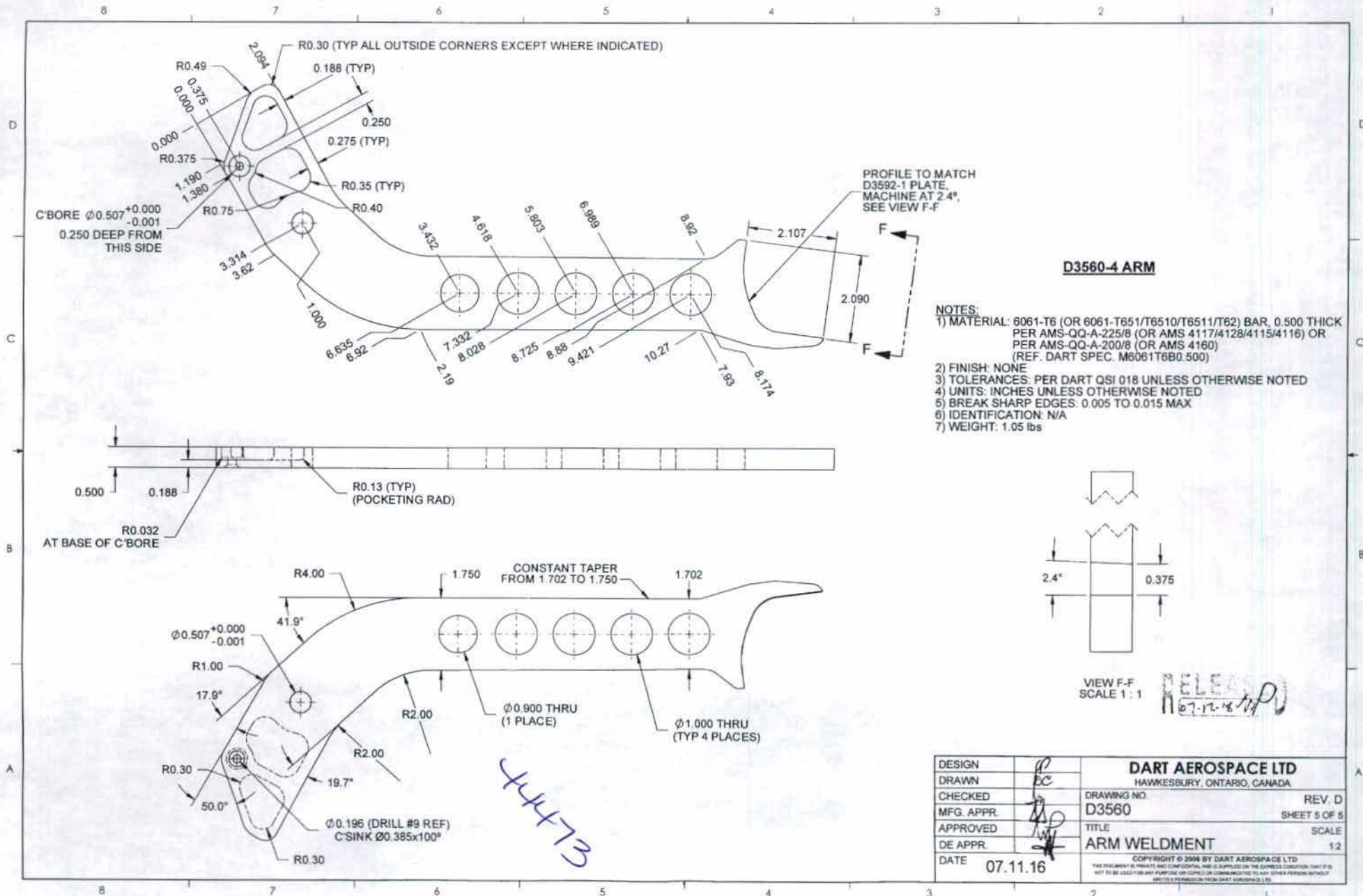


DESIGN	g	<b>DART AEROSPACE LTD</b>	
DRAWN	jc	HAWKESBURY, ONTARIO, CANADA	
CHECKED	g	DRAWING NO.	REV. D
MFG. APPR.	g	D3560	SHEET 3 OF 5
APPROVED	AMP	TITLE	SCALE
DE APPR.	g	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

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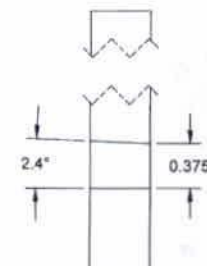






# **D3560-4 ARM**

- NOTES:**  
 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 (REF. DART SPEC. M6061T6B0.500)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 1.05 lbs



**VIEW F-F  
SCALE 1:1**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3560</b>	REV. D
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE <b>ARM WELDMENT</b>	SCALE <b>1:2</b>
DE APPR.			
DATE	07.11.16		

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